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D412-666-011
Job Sheet 182237



005374

Part No: D412-666-011

Job Qty: 1 ea

Part Name: Gross Weight Towing Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP Rev:B Added GHG 002 NG 02-03-06 IPP Rev:C As per Rev C JLM 07-09-07 Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Stores/Pkg-2		SEP 10 2018
110	Packaging	1 pcs	9/14/18	9/14/18	0.00	0.00	Packaging1-4		SEP 10 2018
120	QC	1 pcs	9/14/18	9/14/18	0.00	0.00	QC4		SEP 10 2018
130	Packaging	1 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3-2		SEP 10 2018
135	DC	1 pcs	9/14/18	9/14/18	0.00	0.00	DC		SEP 10 2018
140	QC21-FG	1 Ea	9/14/18	9/14/18	0.00	0.00	QC21		SEP 10 2018

Fg023

Part Op 130 - Identify and pack for shipping as per PPP D412-666-011 Location :FG023
Descriptions: 135 - Photocopy bluefile & type labels per PPP412-666-011 CHG 004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN6-15A	Bolt	4 Ea (4 ea)	90-Start up Operation	56 76004
AN6-45A	Bolt	4 Ea (4 ea)	90-Start up Operation	14 1373210
D2888	Lug	2 Ea (2 ea)	90-Start up Operation	5079824
MS21042L6	Nut	4 Ea (4 ea)	90-Start up Operation	5067266
NAS1149D0663J	Washer	8 Ea (8 ea)	90-Start up Operation	5043782

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN6-15A	4	33	0
	AN6-45A	4	9	0
	D2888	2	3	0
	MS21042L6	4	190	0
	NAS1149D0663J	8	1,362	0

Part Specifications

Specifications could not be found.



Container No: S109060



Part: D412 - 666 - 011

Job No: 182237

Serial No/Batch: S109060

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3, FAA STC SR005631

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1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY -011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

REFERENCE ONLY

REFERENCE ONLY

3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

4.0 PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N-m).

5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

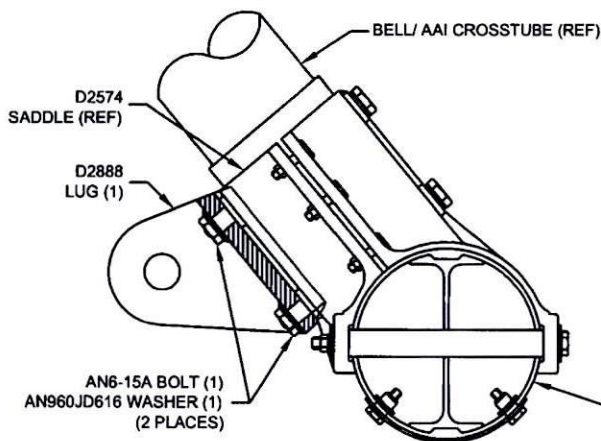


FIGURE 1
(BELL/AAI CROSSTUBES)

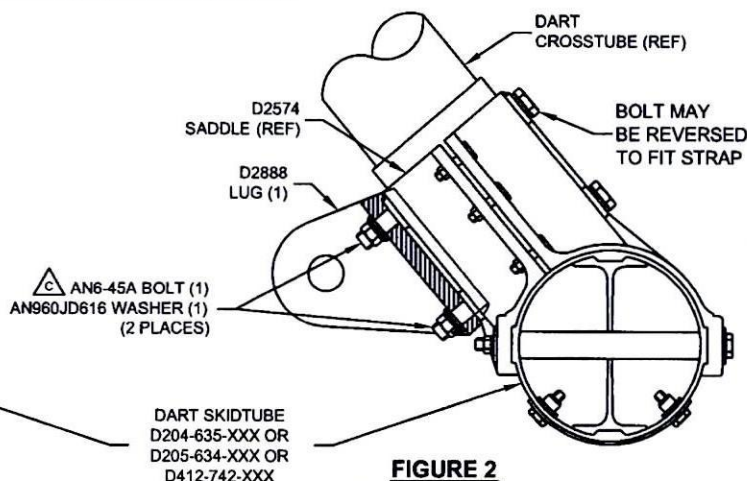


FIGURE 2
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04
A	NEW ISSUE	CP	99.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-666	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		412 GROSS WEIGHT TOWING KIT	1:4
DATE	07.08.10	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Description: GROSS WEIGHT TOWING INSTALLATION[illegible]